

Date: Tuesday, 23/09/2008 10:22:46 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FRONT LEG FITTING ASSY	
Job Number	: 42238		Part Number	: D3762041	
Estimate Number	: 13342		Drawing Number	: D3762 REVA	
P.O. Number	:		Project Number	: N/A	
This Issue	: 23/09/2008 S.O. No. :		Drawing Revision	: A	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : LARGE FAB ASSY		Due Date	: 10/10/2008 Qty: <i>10</i>	
Previous Run	: 40949			Um: Each	
Written By	:				
Checked & Approved By	<i>Jul 08 9.23</i>				
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-06-17 rev.A as per dwg DD verified:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
V		
2.0	D37621	Fitting
Comment: Qty.: 2 Each(s)/Unit Total: 12 Each(s) Fitting batch: <i>B 41007 = 16x</i> SP 08.10.14 <i>10x</i>		
3.0	D37623	Tube
Comment: Qty.: 1 Each(s)/Unit Total: 6 Each(s) Tube batch: <i>B 41008</i> SP 08.10.14 <i>10x</i>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place 2-take pins out before welding 3-weld as per dwg D3762 per QSI004 Alum. rod Batch: <i>M 104855</i> SP 08.10.15 <i>10x</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT LEG FITTING ASS'Y

Job Number: 42238

Part Number: D3762041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



PL08-12-19



10X

Comment: VISUAL WELDING INSPECTION

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



105

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST256*

AS 08/12/22 X

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/22 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11.08.12.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

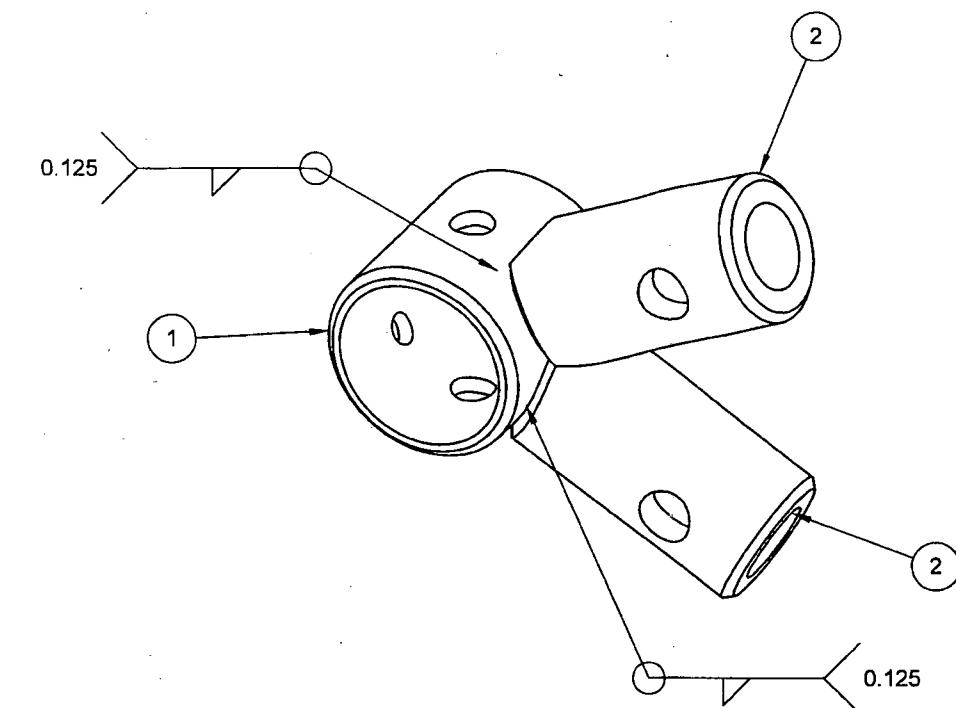
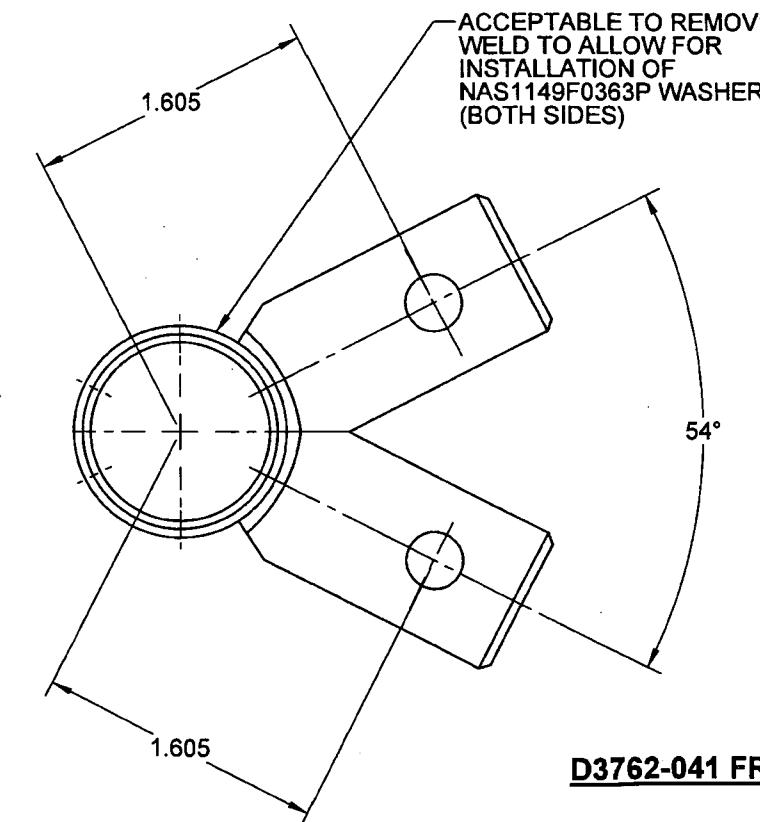
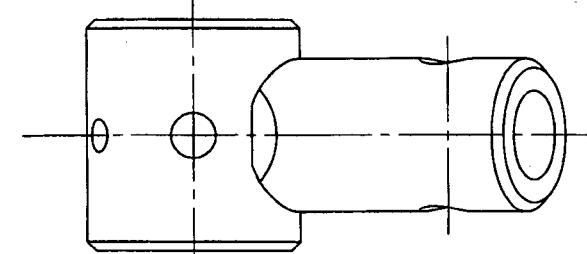
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

D3762-041 FRONT LEG FITTING ASSY

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

A NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	FM	DRAWING NO.	
MFG. APPR.	AV	REV. A	
APPROVED	MW	D3762	SHEET 1 OF 3
DE APPR.	MM	TITLE	SCALE
DATE	08.06.04	FRONT LEG FITTING	NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED

08.06.16 11:17
NO. 120288
B
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
A

8

7

6

5

4

3

2

1

D

D

C

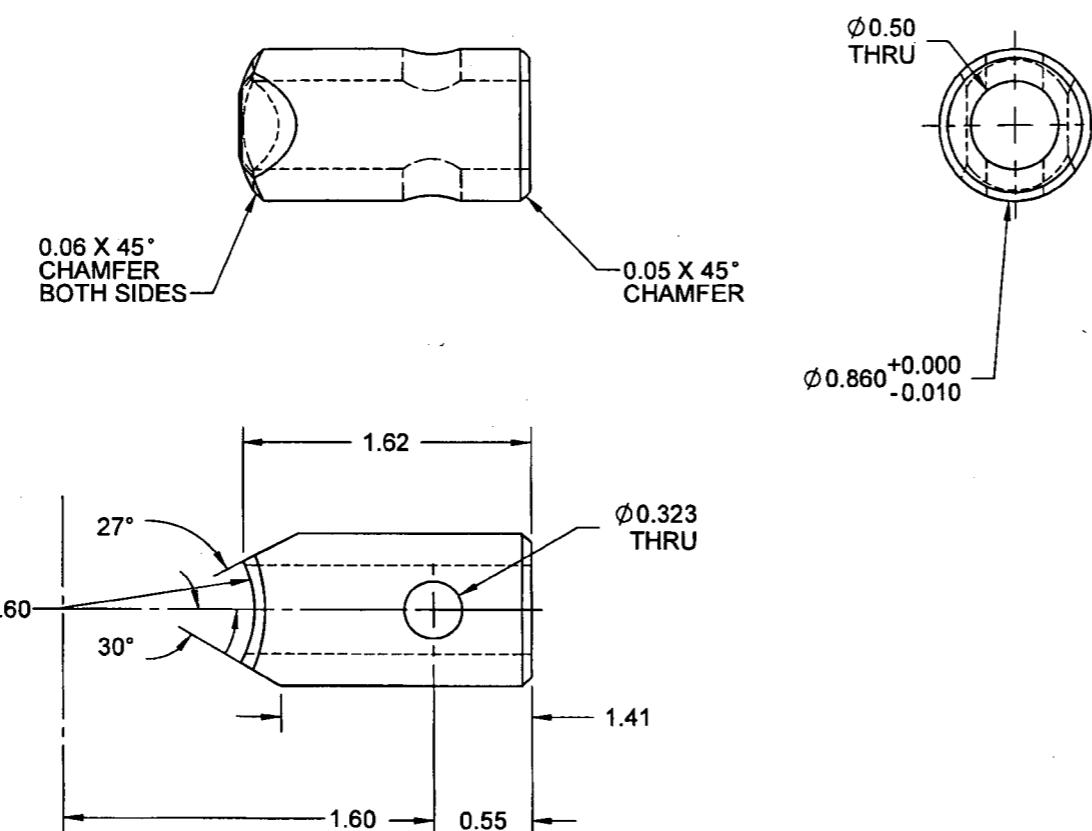
C

B

B

A

A



D3762-1 FITTING

RELEASED
08-06-16 111

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 42238

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	
MFG. APPR.	SD	REV. A	
APPROVED	MM	D3762	
DE APPR.	MM	SHEET 2 OF 3	
DATE	08.06.04	TITLE	
		SCALE	
		FRONT LEG FITTING	
		NTS	

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

6

5

4

3

2

1

D

D

C

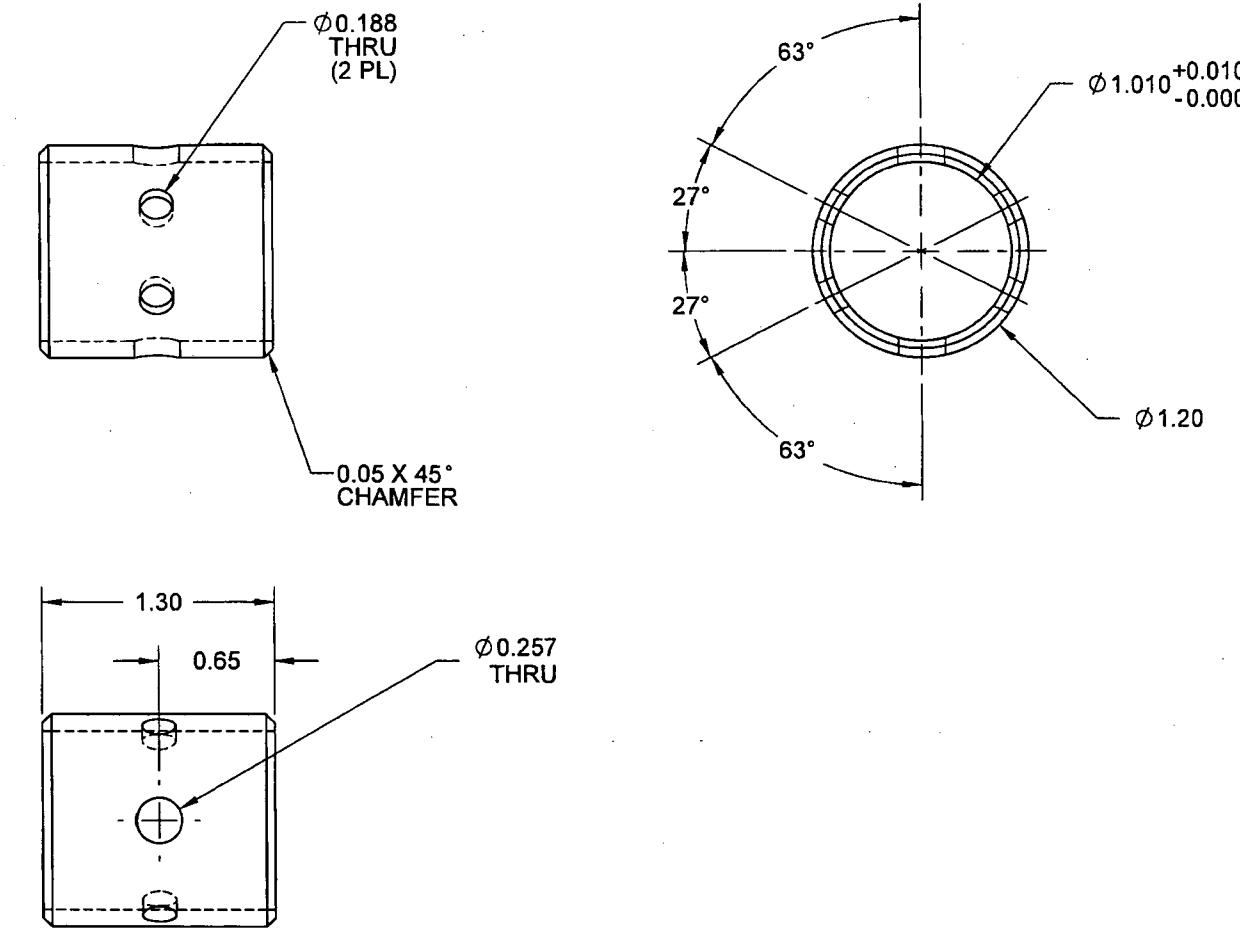
C

B

B

A

A



D3762-3 TUBE

RELEASED
 08.06.16/17
 SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 9238

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RY	DRAWING NO.	
MFG. APPR.	MO	REV. A	
APPROVED	JW	D3762	
DE APPR.	SH	SHEET 3 OF 3	
DATE	08.06.04	TITLE	FRONT LEG FITTING
		SCALE	NTS
		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS	
		NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	
		WRITTEN PERMISSION FROM DART AEROSPACE LTD.	